

Date: Tuesday, 28/04/2009 2:09:59 PM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLAMP
Job Number	: 47562		
Estimate Number	: 11966		
P.O. Number	:	Part Number	: D2055 BK
This Issue	: 28/04/2009 S.O. No. :	Drawing Number	: D2055 C1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 28/04/2009 Type : RMA	Drawing Revision	: C1
Previous Run	: 34365	Material	:
Written By	: <i>[Signature]</i>	Due Date	: 01/05/2009 Qty: 30 Um: Each
Checked & Approved By	:		
Comment	: Est. C 02.03.07 Now turned in house NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R1000	ROUND BAR 1.00"
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Comment: Qty.: 0.1094 f(s)/Unit Total : 3.2823 f(s)

ROUND BAR 1.00"

Material : 6061-T6 rod (QQA-A-225/8)

Batch: *M110966* *mk 09/04/30*

2.0	DOOSAN LATHE	DOOSAN LATHE
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Comment: DOOSAN LATHE
HARDINGE CNC LATHE SMALL
Machine as per Folio FA203
deburr all sharp edges as per dwg

*mk 09/04/30***(30)**

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*mk 09/04/30***(30)**

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*FL 09/05/09***(30)**

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

*UMP / FL**09/05/09***(130)**

6.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

*10:10**FL 09/05/05***(30)**

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 47562

Part Number: D2055

Job Number:



Seq. #:

Machine Or Operation:

Description :

OVEN TEMPERATURE: 320°

FINISH TIME: 10:40

FL 09/05/05 (30)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-02 (30)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 10

9/26

SP

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/06

Job Completion



mf
09-05-06



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2035 PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 09/05/06
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>47562</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/05/01</u>	<u>2</u>	<u>28 part, the wall thickness one side: 110" and the other side: 122" Tool offset 2.c: operator error.</u>	<u>[Signature]</u> <u>DESIGN2</u>	<u>Acceptable for assembly. only used a 10 steper for a mirror bracket in a non-stress area.</u>	<u>[Signature]</u> <u>09/05/01</u>	<u>SD</u> <u>09/05/01</u>	<u>[Signature]</u> <u>DESIGN</u>	<u>[Signature]</u> <u>09-05-01</u>

NOTE: Date & initial all entries